

## Work Order ID 123984

Wednesday, September 17, 2014 9:25:27 AM

Item ID: D3562-042

Revision ID:

Item Name: Step Weldment

Start Date: 9/4/2014 Start Qty: 2.00

1 PART SCRAP  
DESTROY

Accept

Required Date: 9/4/2014 Req'd Qty: 2.00

\*2\*

\*N900040100\*

DUPLICATE

Page 1

Setup Start \*NS1\*

Stop \*NS2\*

Reference:

Approvals:

Process Plan: MFDate: 14-9-17

Tooling:

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	F

100  
**\*100\*** Large Fab 0.00  
 Large Fab  
 Large Fab  
 Memo  
 1-Cut D2622 extrusion as per Dwg D3562  
 2-Deburr and bevel ends for welding

2 14-9-17 DMC

2 CC 14-9-17

110  
**\*110\*** QC6- Inspect dimensions to drawing 0.00  
 QC  
 Quality Control  
 Memo

2 SEP 17 2014

DAS  
24  
9-89

120  
**\*120\*** HandFinish Chemical Conversion Coat per QSI005 4.1 0.00  
 Hand Finishing  
 Memo

2 14-9-17 DMC

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
				Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear		General						
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up
Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure
Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled
Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	
Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	
Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>	
Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>	
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>	
Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>	

Work Order ID 123984

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Wednesday, September 17, 2014 9:25:27 AM

Item ID: D3562-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Step Weldment

Stop

\*NS2\*

Start Date: 9/4/2014 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 9/4/2014 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

2 7/14/9-07

\*130\*

QC

Quality Control

140

Small Fab

0.00

11.4

\*140\*

Small Fab

Memo

0.00

7/14/10-16

Small Fab

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

\*\*\*\*\*Ensure to wipe off any excess magnobond \*\*\*\*\*

A/R Scotch-Weld DP460

Batch: 129414

EXP DATE: Aug 2015

PTO

DQA:

Date: 14/02/08

QA Closed:

Date: 4/17/4

## WORK ORDER NON-CONFORMANCE / UPDATE

**DART**  
AEROSPACE

## Work Order update only

Work Order: <u>123984</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No. <u>D3562-042</u>	Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
NCR No. <u>14-4347</u> NCR No: <u>14-4348</u>										
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design	14.09.25	140	①	- when removing a rivet operator overdrill the rivet hole.	DAS 22 009 14.09.25	• drill 5/32 hole and over install rivet • see attach email	DMC 14.10.02	DAS 9 9-89 14.10.02	DAS DAS 9 9-89 14.10.02	
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
Bending	Bend	Folio/Program	\$139.25			Outside Dimensions	Pressure/Forced			
Centre Not Concentric	BOM/Route	Grain	\$26.23			Over/Under tolerance	Set-up			
Cracks	Broken/Damage/Defect	Hardware	\$258.32			Part Incorrect	Temperature/Cure			
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	(\$423.80)			Part Lost/Missing	Weld			
Cuffs	Contamination	Instructions Incomplete/Unclear	(\$423.80)			Part Moved	Wrong Stock Pulled			
Crushing	Countersink	Misaligned/off center	(\$423.80)			Positioned Wrong				
Heat Treat	Cut Too Short	Mislabeled	(\$423.80)			Power Loss/Surge				
Inspection Strip in Tube	Drawing	Misread	(\$423.80)							
Marks/Chatter	Drill Holes	Off-set	(\$423.80)							
Turning Sequence	Finish	Out of Calibration	(\$423.80)							
Wave/Twist in Tube	Fit/Function	Out of Sequence	(\$423.80)							

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Item ID:	D3562-042	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:							
Item Name:	Step Weldment					Stop *NS2*	
Start Date:	9/4/2014	Start Qty:	2.00	*2*	Cust Item ID:		
Required Date:	9/4/2014	Req'd Qty:	2.00	*2*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC	QC5- Inspect part completeness to step on W/O _____	0.00				1	14.10.16		DAS 9 9.89
Quality Control	Memo	0.00							
160 <b>*160*</b> Large Fab	Large Fab	0.00							DAS 24 9.89
Large Fab	Memo	0.00							
	1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>12-8956</u>								
	2-Grind end cap welds flush as per Dwg D3562								
170 <b>*170*</b> QC	QC10- Inspect visual per QSI004- ground welds Quality Control	0.00				1	14.10.16		DAS 9 38 9.89
	Memo	0.00							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved				TJ					

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>	
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>	

• Work Order ID 123984

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Wednesday, September 17, 2014 9:25:27 AM

Item ID: D3562-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Step Weldment

Stop

\*NS2\*

Start Date: 9/4/2014 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 9/4/2014 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							14-10-16 DAS 9 9-89
190 <b>*190*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							14-10-17 14-10-17
200 <b>*200*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							14-10-17 8349

11/29/2018  
7:50 200°  
8:00

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/>
Part No. _____		Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/>
NCR No. _____		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

Work Order ID 123984

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Wednesday, September 17, 2014 9:25:27 AM

Item ID: D3562-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Step Weldment

Stop

\*NS2\*

Start Date: 9/4/2014 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 9/4/2014 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Wing Walk as per dwg QSI005 4.4 Batch N1294507

\*210\*

HandFinish

Hand Finishing

1a f 06 14 10 07

220

QC3- Inspect Part Finish

0.00

DAS

38

088

09/21/2014

\*220\*

QC

Quality Control

01                                   

230

Identify as per dwg & Stock Location 6A 0.00

\*230\*

Packaging

Packaging

Memo

W/O 126173

0.00

DAS

36

9-89

1X                                   

14/11/03

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

### DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

### AGAINST DEPARTMENT/PROCESS

Skid-tube   
 Machining   
 Thermoforming   
 Large Fab

Crosstube   
 Small Fab   
 Finishing   
 Composite

Water Jet   
 Prod. Eng. Coor.   
 Rec/Store/Packaging   
 Supplier

Engineering   
 Quality   
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

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Item ID:	D3562-042	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Step Weldment						
Start Date:	9/4/2014	Start Qty:	2.00	*2*	Cust Item ID:		
Required Date:	9/4/2014	Req'd Qty:	2.00	*2*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 <b>*240*</b> QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							14/11/5 10 MF 14-11-05

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

## DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

## AGAINST DEPARTMENT/PROCESS

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

# Picklist Print

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Work Order ID: 123984

\*123984\*

Parent Item: D3562-042

\*D3562-042\*

Parent Item Name: Step Weldment

Start Date: 9/4/2014

Required Date: 9/4/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-09 JLM  
IPP rev B ECN 987 07.10.09 EC verified by: DD  
IPP Rev:C ECN1048 07-12-18 DD verified by: EC  
IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E  
13.06.03 PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			100	Each	88.0000	1	2			**	DMC 14-09-17
<b>*D2622-120C*</b>														

Step Extrusion

Location	Loc Qty	Loc Code
HALL	84	
109575	32	
119621	52	(2X)
WA003	4	
101765	1	
115141	3	

D2734		Manufactured	No			140	Each	47.0000	2	4			**	PL 14-07-17
<b>*D2734*</b>														

Step End Plate

Location	Loc Qty	Loc Code
WA003	47	
119286	35	
119498	11	
99709	1	

D3560-042		Manufactured	No			140	Each	4.0000	1	2			**	DMC 14-09-17
<b>*D3560-042*</b>														

Arm Weldment

Location	Loc Qty	Loc Code
WA003	4	
108848	1	
119556	3	(2X)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

## Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function							
				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence							
				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge							
				<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							
				<input type="checkbox"/> Other							

**Picklist Print**

Page 2

Wednesday, September 17, 2014 9:25:26 AM

Work Order ID: 123984

**\*123984\***  
**\*D3562-042\***

Parent Item: D3562-042

Parent Item Name: Step Weldment

Start Date: 9/4/2014

Required Date: 9/4/2014

Start Qty: 2.00

Required Qty: 2.00

D3560-044

Manufactured No

140 Each 2.0000

1 2

\*\*

D4C 14-09-17

**\*D3560-044\***

Arm Weldment

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	2	
	2	

MS20600-AD4W5

Purchased No

160 Each 744.0000

32

64

\*\*

D4C

14-09-17

**\*MS20600-AD4W5\***

Blind Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST310	372	
m129820	372	
WA003	372	
m129472	372	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

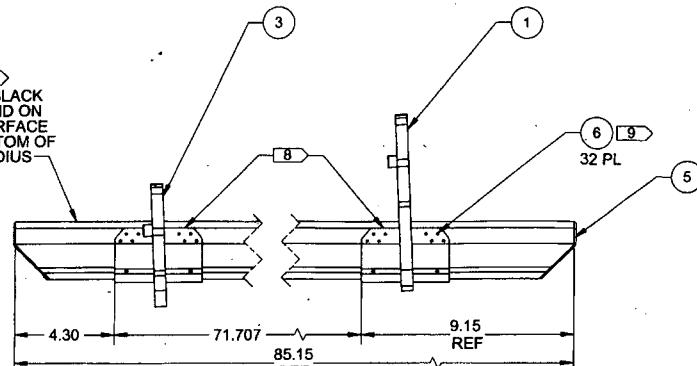
Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear			General						
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
Crushing	Countersink	Misaligned/off center	Positioned Wrong						
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other					
Inspection Strip in Tube	Drawing	Misread							
Marks/Chatter	Drill Holes	Off-set							
Turning Sequence	Finish	Out of Calibration							
Wave/Twist in Tube	Fit/Function	Out of Sequence							

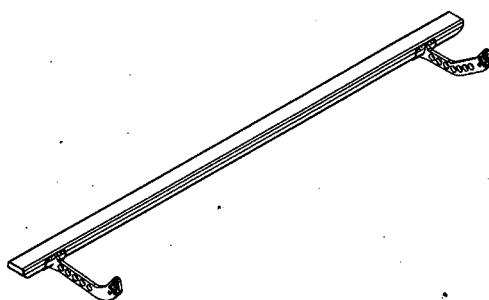
8  
7  
6  
5  
4  
3  
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1  
D  
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A

2  
APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

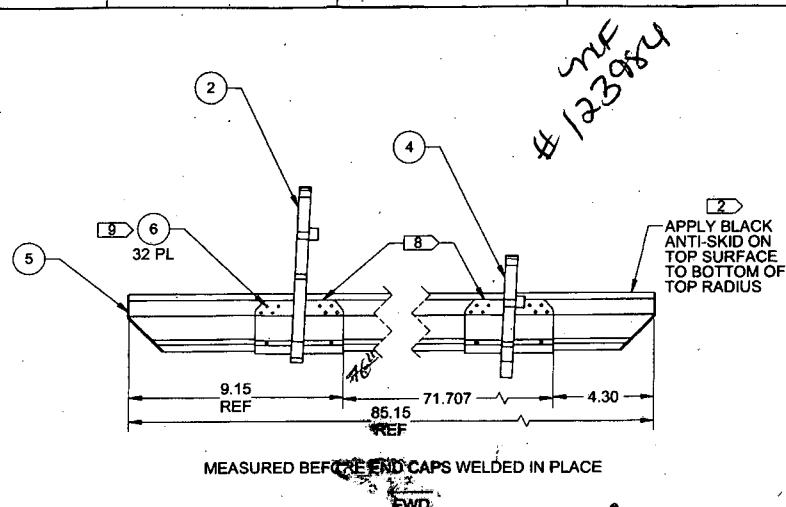


**D3562-041 LH STEP ASSEMBLY**

**NOTES:**

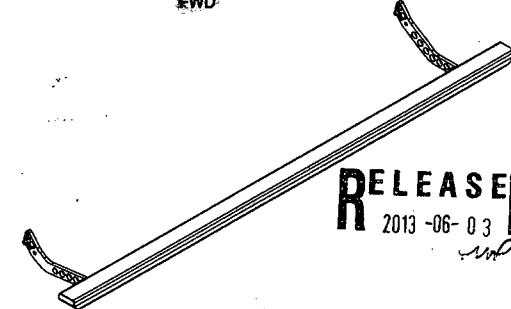
- 1) MATERIAL: N/A
- 2) FINISH:
  - i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
  - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

ITEM No.	QTY -041	QTY -042	P/N	DESCRIPTION
	X	X	D3562-041	LH STEP ASSEMBLY
			D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS20600AD4W5	RIVET



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



**RELEASED**  
2013-06-03

**D3562-042 RH STEP ASSEMBLY**

F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PART 12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE, REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>SP</i>		
DRAWN	<i>DW</i>		
CHECKED	<i>SP</i>		
MFG. APPR.	<i>SP</i>	DRAWING NO.	REV. F
APPROVED	<i>SP</i>	D3562	SHEET 1 OF 2
DE APPR.	<i>SP</i>	TITLE	NTS
DATE	13.05.15	SCALE	
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date: 10/10/2010

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

### Work Order update only

Work Order: _____	<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Use-as-is <input type="checkbox"/>	Suspected Unapproved <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
			Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
			Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

**FAULT CATEGORY**

FAULT CATEGORY									
Landing Gear		General		Process		Material		Environment	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							

8 7 6 5 4 3 2 1

D

D

C

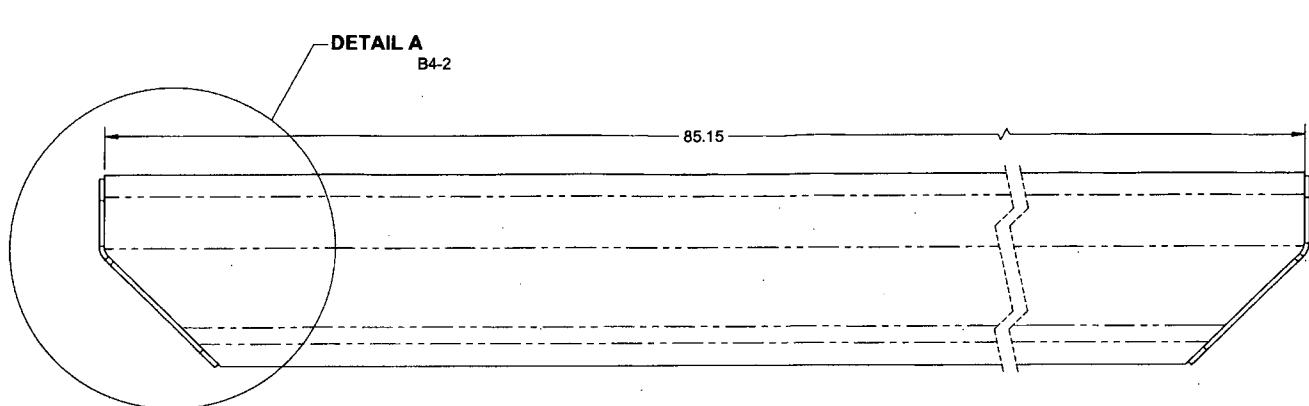
C

B

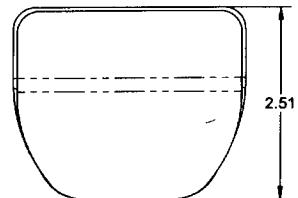
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A

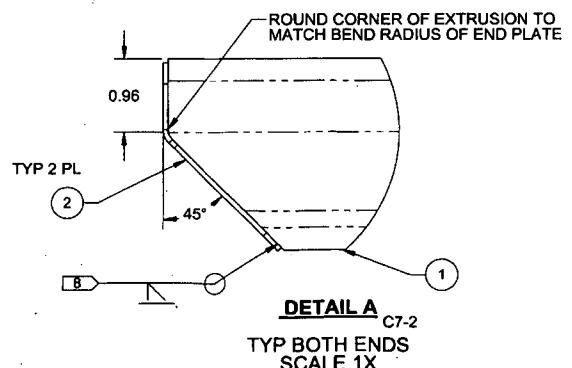
A



ML  
\*123982



**D3562-1 STEP ASSEMBLY**



**RELEASED**  
2013-06-03  
WP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ITEM NO.	QTY	P/N	DESCRIPTION
	-1		STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE

DESIGN	DP	DART AEROSPACE LTD
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA
CHECKED	HP	
MFG. APPR.	AP	DRAWING NO. REV. F
APPROVED	AP	D3562 SHEET 2 OF 2
DE APPR.	AP	TITLE NTS
DATE	13.05.15	STEP ASSEMBLY

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8 7 6 5 4 3 2 1

5 4 3 2 1

3 2 1

1

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date: / /



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

### Work Order update only

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

**FAULT CATEGORY**

## Eric Downing

---

**From:** Marc Bellavance  
**Sent:** Wednesday, September 24, 2014 4:02 PM  
**To:** Patrick Duval  
**Cc:** Eric Downing  
**Subject:** D3562-042 Step Assembly

Pat,

After review with Chris Provencal:

1. The CR3213-5-5 is made of stronger material than MS20600AD4W5;
2. The body of the CR3213-5 rivet is larger than the body of MS20600AD4W5;
3. By comparison, the CR3213-5-5 is stronger than the MS20600AD4W5;
4. Therefore, it would be acceptable to replace the MS20600AD4W5 with CR3213-5-5.

Please print and attach physical copy of this email to the W/O for that step assembly and proceed with appropriate instructions to complete work.

**Marc Bellavance**

*Mechanical Designer / Technical Support*

**DART AEROSPACE**

**T** 1 613 632 5200 > 243

**M** 1 613 676 0992

**F** 1 613 632 9311

**S** [marcbellavance](mailto:marcbellavance)

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